Work Order ID 53810



Page 1

November 18, 2009 12:47:32 PM

Item ID:

D3178-041

Revision ID:

Α Nut Plate Item Name:

Start Date:

QC:

18/11/2009

Start Oty: 12.00 Required Date: 25/11/2009.

Reg'd Oty: 12.00



Accept

Cust Item ID:

Customer:

Réference:

Approvals:

Process Plan:

Date: OF/

Date:

Tooling:

0.00

0.00

SPC (Y/N):

Date:

Date:

Run

Start

Stop

Setup Start

Stop



Sequence ID/ Work Center ID

Draw

Draw

Plan Code

Reject Accept

Reject Number

Draw Nbr

D3178

Rev A

Revision Nbr

100

Waterjet

FLOW CNC Waterjet

C202

: U.S

Operation

Description

Set Up/ Run Hours

Number

Rev.

Qty

Oty

Insp. Stamp

B 9-12-10

DEBURR

PROG REV

Memo

120

OC2- Inspect parts off machine FAI/FAIB

CUT AS PER DWG DWG REV

0.00

QC

Memo

0.00

Quality Control

	•								
W/O:			WO	RK ORDER CHANG	ES				E. s. y
DATE	STEP	PRO	OCEDURE CHAP	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			A-1						
Part No: PAR #:		PAR #:	Fault Categ	jory:	_ NCR: Yes	No DC	A:	Date:	
					QA: N/C Closed: Date:				
NCR:		•	WORK ORDE	R NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC Corrective Action			Section B Verific			Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng			Sign & Section C		Chief Eng	QC Inspector
i									
									-

November 18, 2009 12:47:32 PM

Α

Required Date: 25/11/2009

Item ID:

D3178-041

Setup Start



Stop

Item Name: **Start Date:**

Revision ID:

Nut Plate 18/11/2009

Start Qty: 12.00 .

Req'd Qty: 12.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Accept

Date:

Date:

Run

Start



Stop

Sequence ID/ Work Center ID

130

Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

Set Up/ **Run Hours** Draw Number

Plan Draw Code Rev.

Accept Qty

Reject Qty

Reject Insp. Number Stamp

11/5/80 BC=

140

Small Fab Small Fab

Small Fab

Memo

Memo

0.00

0.00

1- C'sink D3178-1 holes as per Dwg D3178□2- Deburr

150

Quality Control

QC5- Inspect part completeness to step on W/O

	•									
W/O:			W	ORK ORDER CHANG	GES					E . ,
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
										1
-)										
	-									
Part No	:	PAR #:	Fault Cate	egory:	_ NCI	R: Yes	No DQ	ム:	_ Date:	
Resolution:			Disposition	on:	QA	N/C CI	osed:		Date:	
NCR:			WORK ORD	ER NON-CONFORM	ANCE	(NCR)			
DATE	STEP	Description of NC			Section B			cation	Approval	Approval
DAIL	SILI	Section A	Initial Chief Eng			Sign & Date	Section C		Chief Eng	QC Inspector
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						-				

Work Order ID 53810

Page 3

November 18, 2009 12:47:32 PM

Α

Required Date: 25/11/2009

Item ID:

D3178-041

Accept

Setup Start



Stop

Item Name: **Start Date:**

Revision ID:

Nut Plate 18/11/2009

Start Qty: 12.00 Req'd Qty: 12.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Run

Start



Stop

Sequence ID/ **Work Center ID**

160

HandFinish

Hand Finishing

Operation Description

Chemical Conversion Coat per QSI005 4.1

Set Up/

Run Hours

Draw Number

Plan Draw Code Rev.

Date:

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

Memo

0.00

0.00

ump 09/10/16

170

QC

Quality Control

OC3- Inspect Part Finish

Memo

0.00

SK 09-12-16

180

Small Fab Small Fab

Small Fab

Memo

Assemble as per Dwg D3178

0.00

0.00

G308/12/18 28

W/O:		146	WORK ORDER CHANGES									
DATE	STEP	PR	OCEDURE CHAI	NGE	E	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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-							-			· r		
										• •		
Part No:P		PAR #:	Fault Cate	Jory:	NCR:	Yes N	o DQ	A :	Date:			
	Re	esolution:	Disposition	n:	QA: N	/C Clos	sed:		Date:			
NCR:	·		WORK ORDE	R NON-CONFORM	ANCE (NCR)						
DATE	STEP	Description of NC	Corrective Action Section B			Verification Ap			Approvai	Approval		
	10.2.	Section A	Chief Eng	Initial Action Description Chief Eng Chief Eng		ign & Date	i Section C		Chief Eng	QC Inspector		
		,										
-												
			,									
							<u> </u>					
												
							:					

Work Order ID 53810

Α



Page 4

November 18, 2009 12:47:32 PM

Required Date: 25/11/2009

Item ID:

D3178-041

Accept

Setup Start



Revision ID:

Item Name: Nut Plate

18/11/2009

Start Oty: 12.00

Reg'd Otv: 12.00

Cust Item ID: Customer:

Stop

Reference:

Start Date:

Approvals:

Process Plan: Date:

Tooling:

Date:

Date:

Run

Start



Stop

Sequence ID/ Work Center ID

190

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

OC: Date:

Memo

Run Hours

Set Up/

SPC (Y/N):

Draw Number Draw Plan Rev. Code

Accept Otv countres Reject Qty

Reject Number

Insp. Stamp

200

Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

0.00

210

Quality Control

OC21- Final Inspection - Work Order Release

Memo

Memo

0.00

0.00

1209112121

	•								
W/O:			V	ORK ORDER CHANGE	S				1 E .
DATE	STEP	PROC	EDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									<u>}</u>
			11,000						
Part No	:	PAR #:	_ Fault Ca	tegory:	NCR: Yes	No DQ	A:	_ Date: _	
Resolution:									
NCR:		W	ORK OR	DER NON-CONFORMAI	NCE (NCF	₹)			 <u>-</u>
DATE	STEP	Describition of NC			verific			Approval	Approval
	JILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		ion C	Chief Eng	QC Inspector
				÷				[
; 									

Picklist Print

November 18, 2009 12:47:39 PM

Work Order ID: 53810

D3178-041RevA Parent Item:

Parent Item Name: Nut Plate

Comments:

IPP REV: B NOW ON WATERJET JLM VERIFIED BY:DD



112442

Start Date: 18/11/2009

Required Date: 25/11/2009

Page 1

Start Qty: 12.00

Required Qty: 12.00

HR 9-12-16

Component Item ID/	Aaplacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
Item Name	Item ID	Purch	Item	Location	Location	Seq ID	Measure	Hand	Qty To Pick	Issued	Issued	
MS21059L3		Purchased	No			100	Each	276.0000	48.0000	12/10	SI	



M5052H32S.063

5052-H32 .063 Sheet

Purchased	No

Purchased

Warehouse	<u>Lo</u>	c Qty	Loc Code	1	
Location				j	
Main Warehouse					
ST		276			
109962		11 265	f.		113
111923	180	sf	121.3237	0.4396	1,5

Warehouse	Loc Qty	Loc Code
<u>Location</u>	<u>Eac Qty</u>	<u> Loc Couc</u>
Main Warehouse		
MAT	121.3237	1
103755	1.3237	
107276	24	

No

96 180 7,861.000 96.0000 Each

726501

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	7861	
104374	3861	
110398	4000	









W/O:			W	ORK ORDER CHAN	IGES			<u>.</u>		ı y
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cat	egory:	NCR	l: Yes I	No DQ	A :	Date:	
					QA: N/C Closed:					
NCR:			WORK OR	DER NON-CONFORI	MANCE	(NCR				
DATE	STEP	Description of NC			Section B Verific				Approval	Approval
		Section A	Initial Chief Eng	Action Descriptio Chief Eng	on	Sign & Date	Secti	on C	Chief Eng	QC Inspector
					j					
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		,		10.						
		•								

DART AEROSPACE LTD	Work Order:	53810
Description: Nut Plate	Part Number:	D3178-1
Inspection Dwg: D3178 Rev: A		Page 1 of 1

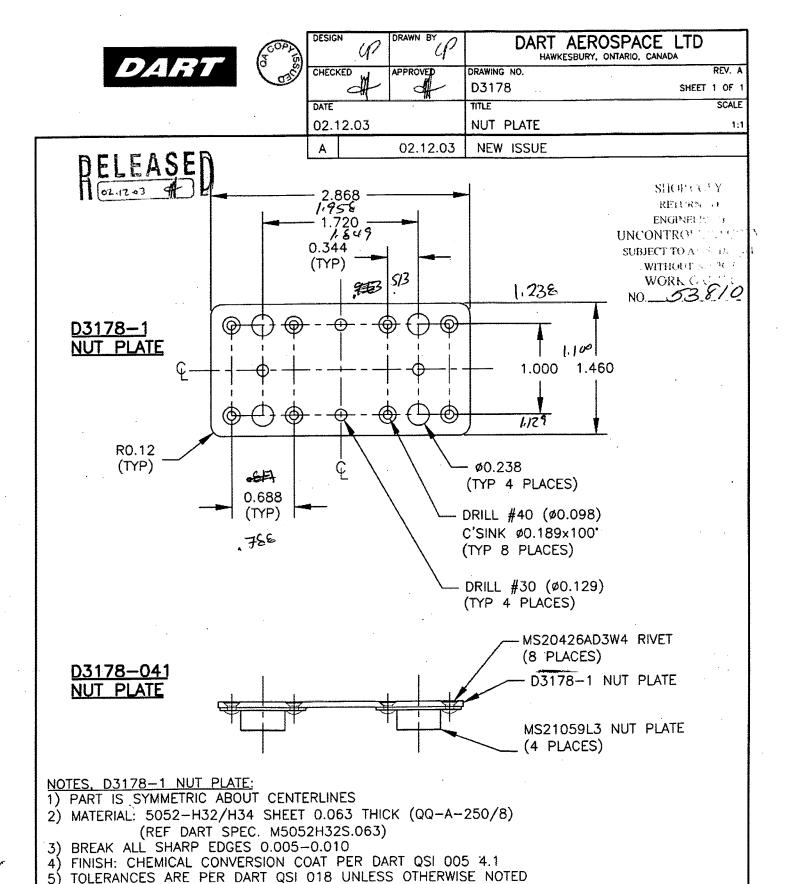
FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.868	+/-0.010	2.875	×			
1.460	+/-0.010	1,466	5			
1.720	+/-0.005	1,721	X			·
0.344	+/-0.005	344				
1.000	+/-0.005	1.004) by			
0.688	+/-0.005	,687	8			
R0.12	+/-0.030	113				
Ø0.238	+0.005/-0.000	240	×			
Ø0.098	+0.005/-0.000	, 099	5-		0.0	
Ø0.129	+0.005/-0.000	1799	Υ			
0.063	+/-0.010	,064	>			
			,			
					<u>_</u>	

Measured by:	Audited by:	Prototype Approval:	N/A
Date: 9-12-10	Date: 07/10/11	Date:	N/A

Rev	Date	Change		Revised, by	Approved
Α	04.02.25	New Issue	P/O K10017	KJ/RF 🛠	



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